

Work Order ID 58084

April 22, 2010 2:54:28 PM



Page 1

Item ID: D2252-1

Accept



Setup Start



Revision ID:

Item Name: Frame

Stop



Start Date: 22/04/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten initials

Date: 10-11-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1- Cut as per dwg D2252
2- Deburr and remove identification markings on tube

SAD

10-04-27

Handwritten circled 8

110



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

S1010429

Handwritten circled 48

120



Identify as per dwg & Stock Location: *WA*

0.00

Packaging

Memo

0.00

Packaging

10-04-29

Handwritten circled 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/29 *[Signature]*
B810-4-29
(5)

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NOTE: Date & initial all entries

Picklist Print

April 22, 2010 2:54:33 PM

Page 1

Work Order ID: 58084

Parent Item: D2252-1

Parent Item Name: Frame

Comments:

Start Date: 22/04/2010

Required Date: 29/04/2010

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	8.6105	17.8947			
304 SQ Tube .75x.75x.065W												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

8.610463158

111148

2.7967

113956

2.863

114137

2.95076316

114482

17.8947

SAD 10-04-27

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2252-041	BASKET ASSEMBLY
3		X	D2252-043	LID ASSEMBLY
7	2	2	D2221-1	RIB
8	5		D2235-1	RIB
9	2	2	D2252-1	FRAME
10		2	D2252-7	FRAME
11	1		D2252-9	FRAME
12	1		D2252-11	FRAME
13	1		D2252-13	FRAME
14	1		D2252-15	FRAME
15	4		D2252-17	FRAME
16		1	D2252-23	FRAME
17	2		D2253-1	LUG
18	2		D2254	GUSSET
19	1	1	D2327-3	BUSHING
20		1	D2329	LABEL PLATE
21	4	2	D2581	MOUNTING CHANNEL
22		2	D2989-19	RIB
23	3		D3748-1	HINGE HALF
24		3	D3749-1	HINGE HALF

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58084
2510-4-22

RELEASED
8/10/18

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 23 AND 24 REPLACE D2232-1/-3; STRETCHED LID FROM 95.27" TO 96.00"; ITEM 7 REPLACES D2252-3/-19; ITEM 19 (ON LID) REPLACES D2327-1; ITEM 22 REPLACES D2252-21; UPDATED TOOLING (ZN A6-5). P/N REASON: SEE PAR#09-006.	MB	09.02.03
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. SHT 2 VIEWS INVERTED FOR CLARITY. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1 & D2. ADDED D2231-1/-3 & D2252-19.	MB	05.11.10
D	MODIFIED LATCH, D2581 WAS D2255-3	BK	99.09.14
C	RE-DRAWN	BK	95.12.11
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JB		
CHECKED	JB	DRAWING NO.	REV. G
MFG. APPR.	JB	D2252	SHEET 1 OF 6
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	BASKET ASSEMBLY (206L)	NTS
DATE	09.02.03	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE UNLESS IT IS SO INDICATED BY THE SUPPLIER OR OTHERWISE BY THE USER.</small>	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

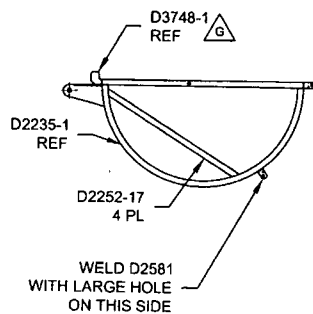
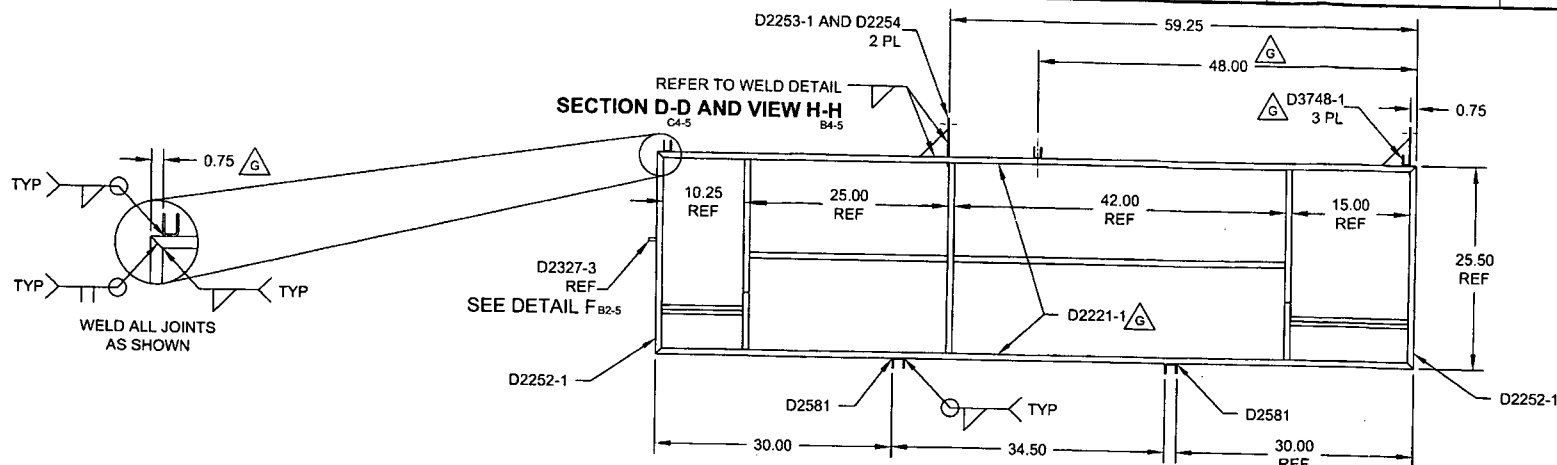
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries



BASE FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

D2252-041 BASE FRAME ASSEMBLY

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2252	SHEET 3 OF 6
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9/2/03

W/058084

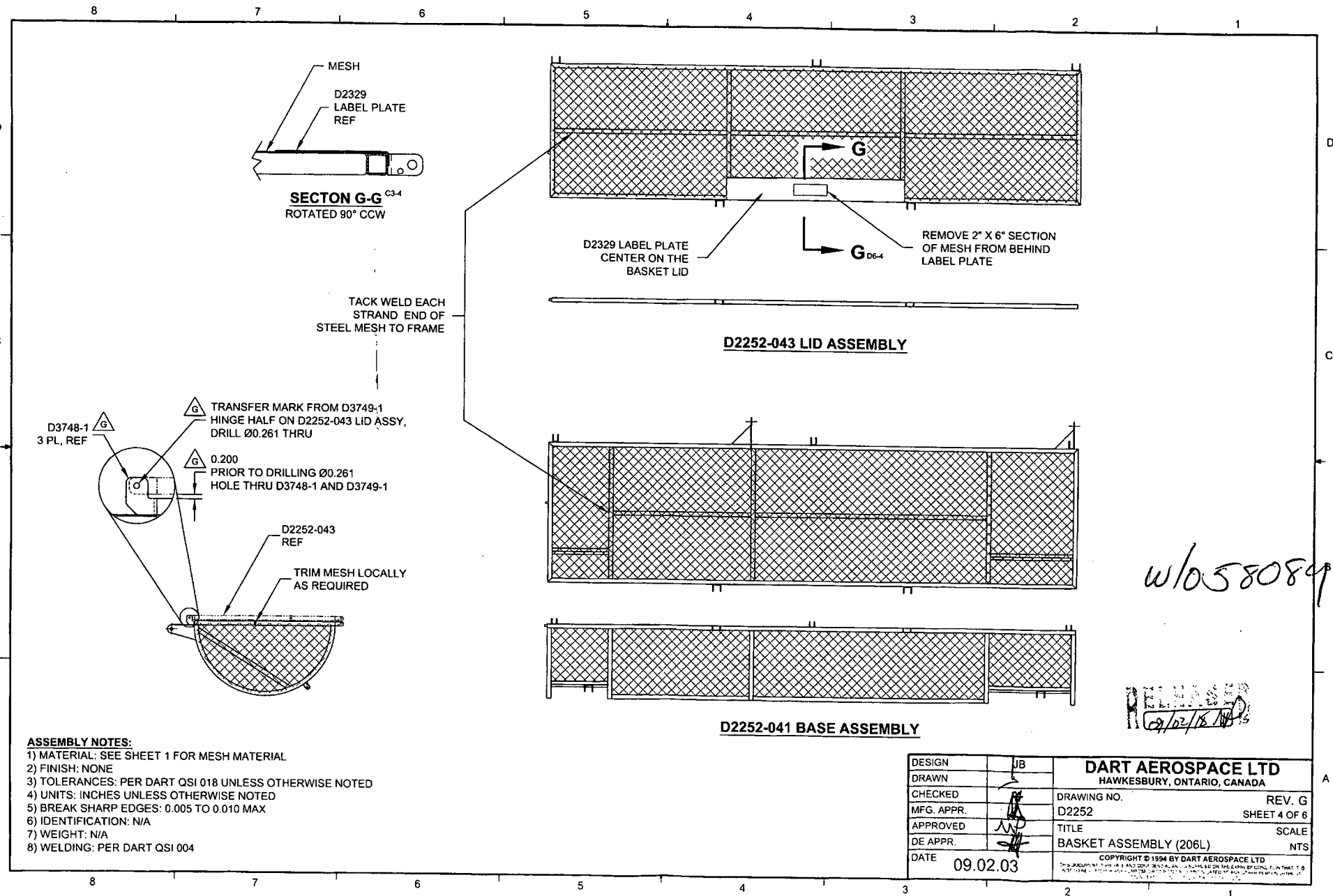
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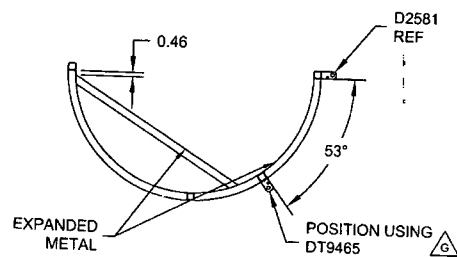
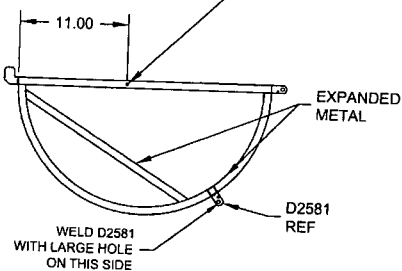
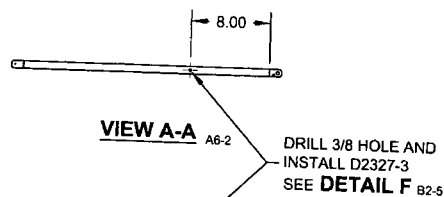
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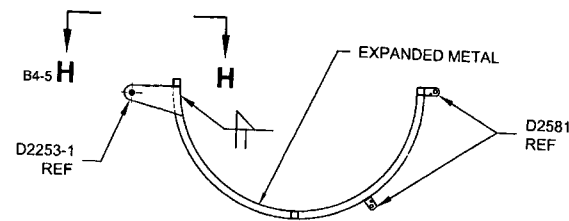
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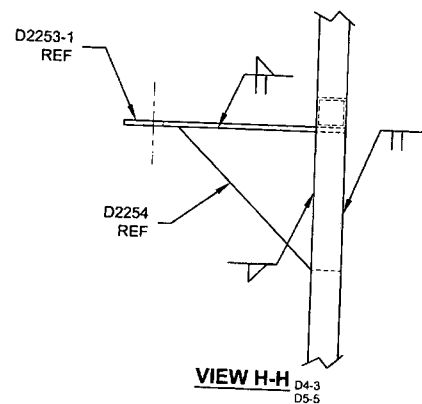
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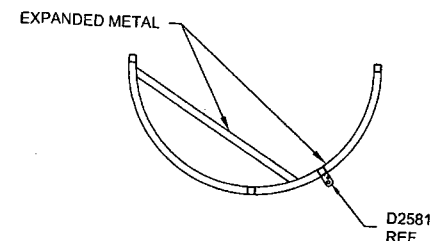
SECTION C-C A5-3



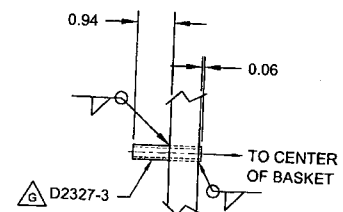
SECTION D-D D5-3



VIEW H-H D4-3 D5-5



SECTION E-E A2-3



DETAIL F C5-3
SPACER INSTALLATION C6-2

W10 58084

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09/2/84

DESIGN	JE	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2252	SHEET 5 OF 6
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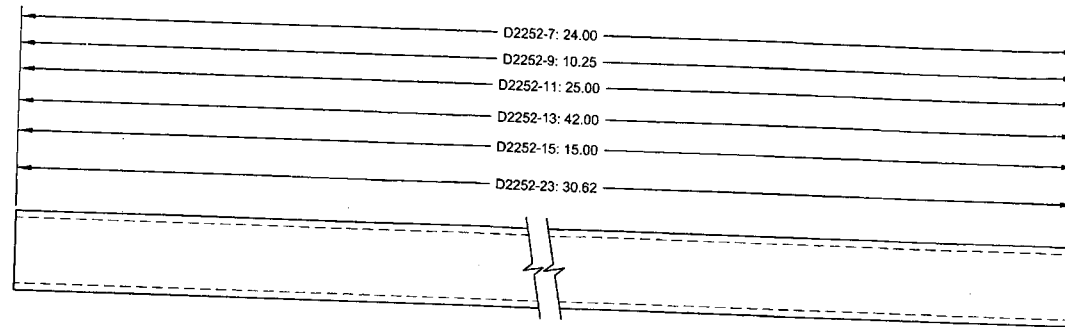
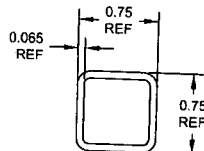
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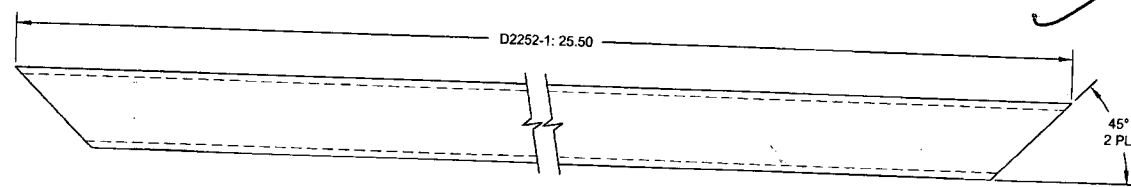
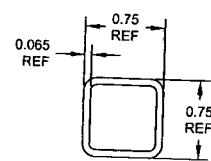
NOTE: Date & initial all entries

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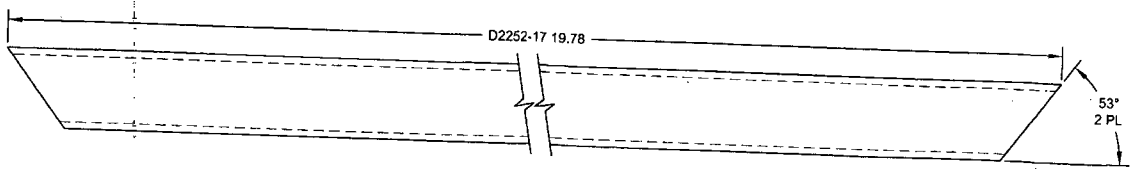
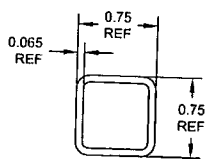


D2252-7: 24.00
D2252-9: 10.25
D2252-11: 25.00
D2252-13: 42.00
D2252-15: 15.00
D2252-23: 30.62

D2252-7 FRAME
D2252-9 FRAME
D2252-11 FRAME
D2252-13 FRAME
D2252-15 FRAME
D2252-23 FRAME



D2252-1 FRAME








D2252-17 FRAME

w/1058084

RELEASED
29/02/81

- NOTES:**
1) FRAME MATERIAL: SEE SHEET 1
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2252 TITLE BASKET ASSEMBLY (206L) COPYRIGHT © 1994 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR DISSEMINATION TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	
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CHECKED			SHEET 6 OF 6
MFG. APPR.			SCALE
APPROVED			NTS
DE APPR.			
DATE	09.02.03		

8 7 6 5 4 3 2 1

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